

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018961**Date Inspected:** 14-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower / OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #11

This QA Inspector observed the following work in progress

Tower

Shielded Metal Arc Welding (SMAW)

Weld joint # 20B, 21B located on North tower, Lift 5, Bracket ND1-BRSA5 -2. Welder is identified as 040720. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 –B –U4B.

Weld joint # 21B, 22B located on South tower, Lift 5, Bracket SD1-BRSA5 -1. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified as Li Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 –B –U4B.

Orthotropic Box Girder (OBG)

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Shielded Metal Arc Welding (SMAW)

Weld joint # 007, 008 located on Bike path BK004ASD1 -019. Welder is identified as 040655. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B –P-2313 –TC –P4.

Repair welding of Weld joint # 003 located on Bike path BK004ASD1 -022. Welder is identified as 041271. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xing. The welding variables recorded by QC appeared to comply with the WPS – 345-SMAW-1G (1F) -Repair.

Repair welding of Weld joint # 023 located on Bike path BK004ASD1 -022. Welder is identified as 044541. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xing. The welding variables recorded by QC appeared to comply with the WPS – 345-SMAW-1G (1F) -Repair.

Bay #10

This QA Inspector observed the following work in progress

Tower

Shielded Metal Arc Welding (SMAW)

Repair welding of Weld joint # 69 located on North Tower, Lift4, Skin B, Façade support plate NSD1- FBSA4 -1A/C. Welder is identified as 050038. ZPMC Quality Control (QC) Inspector is identified as Zhu Feng. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -2G (2F) -Repair.

Weld joint # 15, 16 located on South tower, Lift 5, Skin E Cover plate. Welder is identified as 040582. ZPMC Quality Control (QC) Inspector is identified as Xu Le Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4314 –TC –P4 -2.

Weld joint # 13, 14 located on East tower, Lift 5, Skin E Cover plate. Welder is identified as 040667. ZPMC Quality Control (QC) Inspector is identified as Xu Le Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4314 –TC –P4 -2.

Orthotropic Box Girder (OBG)

Flux cored Arc welding (FCAW)

Weld joint # 039, 040 located on Bike path BK 004A1 -026. Welder is identified as 056200. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B –T -2332 -Esab.

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Weld joint # 041, 042 located on Bike path BK 004A1 -026. Welder is identified as 500363. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B –T -2332 -Esab.

Shielded Metal Arc Welding (SMAW)

Weld joint # 001, 005 located on Bike path BK 004A1 -026. Welder is identified as 052493. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B –T -2312 –TC –P4.

Weld joint # 006, 010 located on Bike path BK 004A1 -026. Welder is identified as 053930. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B –T -2312 –TC –P4.

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Hu (15002048250), who represents the Office of Structural Materials for

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your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer